

# Work Order ID 80927

Monday, March 05, 2012 11:39:37 AM

**\*80927\***

Page 1

Item ID: D4420-043

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Top Leg Support Assembly

Start Date: 3/5/2012 Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 3/6/2012 Req'd Qty: 2.00

**\*2\***

Customer:

*SHIP Today*

Reference:

Approvals: Process Plan:

Date: *12-03-05* Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4420

B

110

Pick Kit

**\*110\***

Packaging

Memo

0.00

Packaging

*-D4006-3 MF 12-03-05*

120

*Gloss grey*  
Grey Sandtex (Ref: 4.3.5.6) per QSI005 4.3

**\*120\***

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

*12h50*  
*320°F*  
*1h20*

*2 MF 12/03/05*

130

QC3- Inspect Part Finish

**\*130\***

QC

Memo

0.00

Quality Control

*2 BL 12-3-5*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 80927**

Monday, March 05, 2012 11:39:37 AM

**\*80927\***

Page 2

Item ID: D4420-043

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Top Leg Support Assembly

Start Date: 3/5/2012 Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 3/6/2012 Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

140

**\*140\***

Small Fab

Small Fab

Memo

1-Assemble as per dwg D4420

0.00

0.00

150

**\*150\***

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

160

**\*160\***

Packaging

Packaging

Identify as per dwg & Stock Location **39 H**

Memo

0.00

0.00

12/23/05 (2)

(40)

12/15/05 (2)

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 80927**

Monday, March 05, 2012 11:39:37 AM

**\*80927\***

Page 3

Item ID: D4420-043

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Top Leg Support Assembly

Start Date: 3/5/2012 Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 3/6/2012 Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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170

QC21- Final Inspection - Work Order Release

0.00

**\*170\***

QC

Memo

0.00

Quality Control

MLJ 12/03/05

MF  
12-03-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

Monday, March 05, 2012 11:39:36 AM

Page 1

Work Order ID: 80927

Parent Item: D4420-043

Parent Item Name: Top Leg Support Assembly

Start Date: 3/5/2012

Required Date: 3/6/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP revA 11.06.30 new issue EC verified by:JLM  
rev.b DD verf:EC

IPP revB 12.03.05 as per dwg

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4006-3 Channel		Manufactured	No			110	Each	9.0000	1	2			
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Location	Loc Qty	Loc Code
----------	---------	----------

GA	7	
----	---	--

73556	7	
-------	---	--

ST107	2	
-------	---	--

72752	2	
-------	---	--

MS20426AD3-3  
RIVET

12.03.05

QSI 042

Purchased No

140	Each	3,996.0000	2	4
-----	------	------------	---	---

12-03-05

Location	Loc Qty	Loc Code
----------	---------	----------

ST316	3996	
-------	------	--

104374	1024	
--------	------	--

110398	2972	
--------	------	--

119109

12/03/05

MS21059L4  
Nutplate

Purchased No

140	Each	52.0000	1	
-----	------	---------	---	--

12/03/05

Location	Loc Qty	Loc Code
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ST301	52	
-------	----	--

117887	3	
--------	---	--

119623	49	
--------	----	--

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

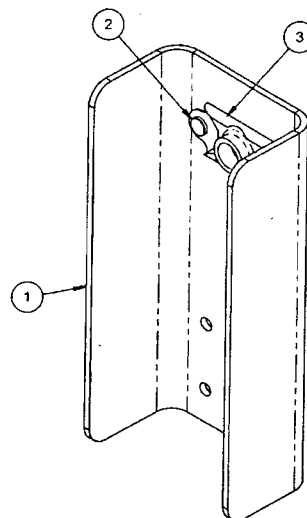
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries



ITEM	QTY -043	P/N	DESCRIPTION
	X	D4420-043	TOP LEG SUPPORT ASSY
1	1	D4006-3	CHANNEL
2	2	MS20426AD3-4	RIVET
3	1	MS21059L4	ANCHOR NUT



**D4420-043 TOP LEG SUPPORT ASSY**

#80927

RELEASED  
2012-03-08  
MT

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "ANSI 61 GREY" (4.3.5.15) PER DART QSI 005 4.3 BEFORE INSTALLATION OF MS21059-4 ANCHOR NUTS
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4420-043" AND B/N PER QSI 044 6.1
- 7) WEIGHT: 0.09 lbs

DESIGN	1	<b>DART AEROSPACE LTD</b>	
DRAWN	1	HAWKESBURY, ONTARIO, CANADA	
CHECKED	1	DRAWING NO.	REV. B
MFG. APPR.	1	D4420	SHEET 2 OF 4
APPROVED	1	TITLE	SCALE
DE APPR.	1	TOP SUPPORT ASSY	NTS
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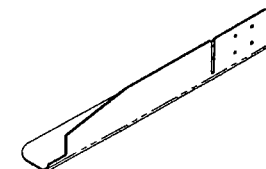
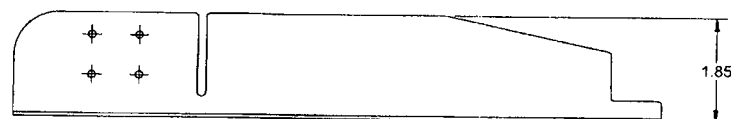
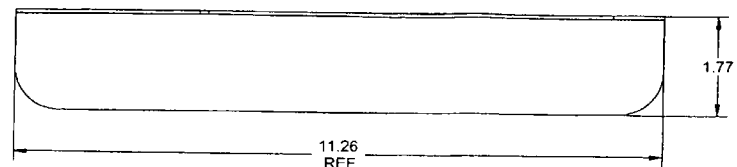
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

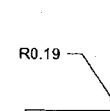
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



180927



# **D4420-1 ANGLE**

## **NOTES:**

- 1) MATERIAL: MADE FROM D4420-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.22 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4420	SHEET 3 OF 4
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RELEASED  
2012-03-02  
MD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

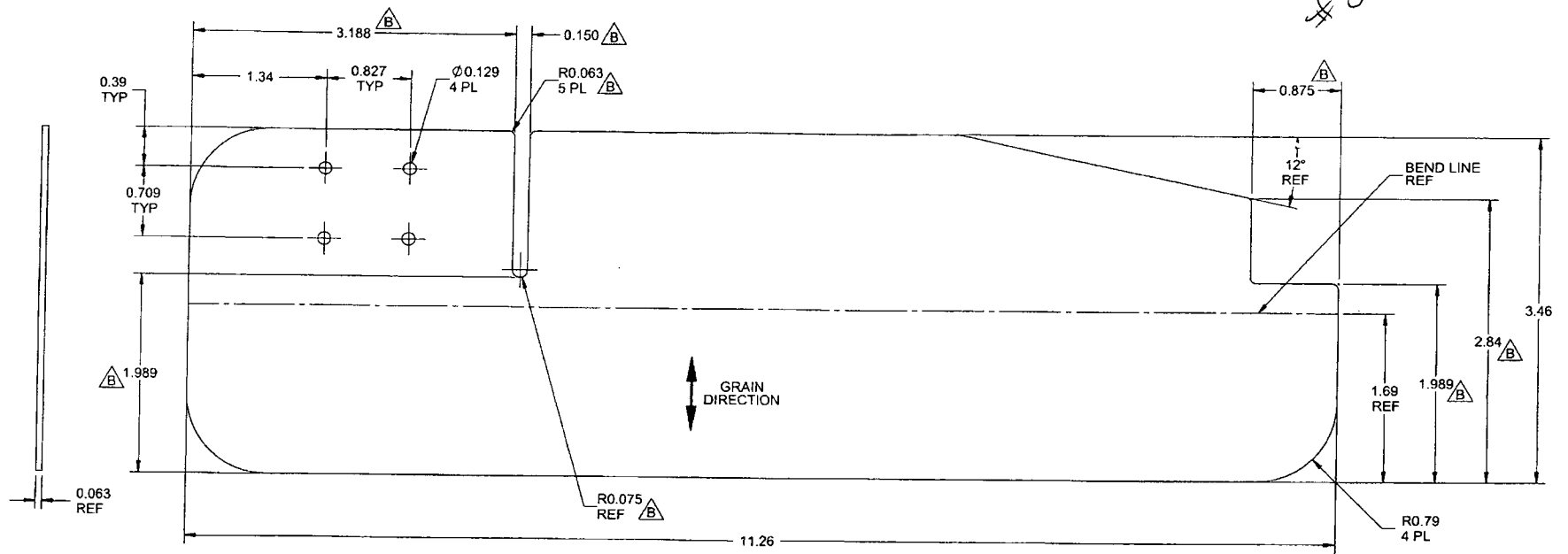
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

#80927



**D4420-1F FLAT PATTERN**

RELEASED  
2012-03-03  
JH

- NOTES:**
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK  
PER QQ-A-250/4 OR AMS-QQ-A-250/4  
OR AMS 4037 OR ASTM B209  
REF DART SPEC M2024T3S.063
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.22 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4420	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		TOP SUPPORT ASSY	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries